

# Work Order ID 110651

\*110651\*

Page 1

Tuesday, January 07, 2014 3:02:16 PM

Item ID: D3322-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Pod Assembly  
 Start Date: 1/7/2014 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 2/21/2014 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: CZ Date: 14/01/07 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2202	REV G
D3322	Rev A

100 PURCHASING 0.00

\*100\*

Purchasing

Purchasing

## Memo

Issue P/O: 22543

Description:

D2202-1 Pod Lid D2202-5 Pod Base

Supplier: Delastek

Copy of Certificate of Conformity and Process sheet from Delastek is required

SHIP TO DELASTEK QTY (1) D3048-1

QTY (3) D3001-1

CZ 14/01/08 ①

110 Receive & Inspect for Damage & Mat'l Certs 0.00

\*110\*

Packaging

Packaging

## Memo

Ensure certificate of conformity and process sheet from Delastek is attached

Rec'd 1/9/14

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 110651****\*110651\***

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Tuesday, January 07, 2014 3:02:17 PM

Item ID: D3322-041      Accept      \*N900040100\*      Setup Start \*NS1\*  
Revision ID:      Stop \*NS2\*  
Item Name: Pod Assembly  
Start Date: 1/7/2014      Start Qty: 1.00      \*1\*      Cust Item ID:  
Required Date: 2/21/2014      Req'd Qty: 1.00      \*1\*      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start \*NR1\*  
QC:      Date:      SPC (Y/N):      Date:      Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing  Memo Visual inspection. Check for void spot and pins. Check over all dimensions as per Dwg D2202.	0.00  0.00				1		DAS 27 9/89 14/10/20	
130 *130* Small Fab Small Fab	Small Fab  Memo Assemble as per Dwg D2694 & D3322	0.00  0.00				1		DAS 27 9/89 14/10/20	
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00						5 14/10/22	

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 110651****\*110651\***

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Item ID: D3322-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Pod Assembly  
Start Date: 1/7/2014 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 2/21/2014 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>SA</u>	0.00							
<b>*150*</b>									
Packaging	Memo	0.00				1	545	W/10/22	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

14/10/22 JG

AA-10-22

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

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Page 1

Work Order ID: 110651

Parent Item: D3322-041

Parent Item Name: Pod Assembly

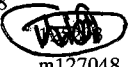
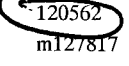
Start Date: 1/7/2014


Required Date: 2/21/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A04.11.12New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AD62ABS rivet		Purchased	No			130	Each	49.0000	38	38		14/10/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST278		49		B12848					
					m127048	7		B127048					
						42							
AD64ABS Pop Rivets		Purchased	No			130	Each	146.0000	43	43		14/10/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST278		146							
					123969	46		M128728					
					125147	100							
AD66ABS Pop Rivet		Purchased	No			130	Each	230.0000	2	2		14/10/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST278		230							
					112784	230		<del>M12848</del>					
AN4-5A BOLT		Purchased	No			130	Each	479.0000	19	19		14/10/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		479							
					m127817	379							
						100							

NA 

DQA:

Date: 14/12/08



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 8/10/11 Date: 14/12/12

Work Order update only ☐

Work Order: 110651	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. D3322-041		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. 144279		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14/10/22	130	2	Replace AD66ABS by AD64ABS Parts are too long	14.10.22	Rivets are too long  AD64ABS X 2 14128728	DAS P7 14/10/22	5 14/10/22	5 14/10/22
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
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## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

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Work Order ID: 110651

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 1/7/2014

Required Date: 2/21/2014

Start Qty: 1.00

Required Qty: 1.00

AN4-6A Purchased No 130 Each 1,356.0000 1 1 14/10/20 DAS 27 9-89

BOLT

Location Loc Qty Loc Code

ST355 250

M127410 250

ST514 1106

M126317 856

M127817 250

AN526C632R7

Purchased

No

130

Each

114.0000

2

2

14/10/20 DAS 27 9-89

Screw

Location Loc Qty Loc Code

ST345 114

112385 53

117317 61

D2202-1P

Purchased

No

110

Each

0.0000

1

1

110651 DAS 32 9-89

Side Pod Lid, 350

D2202-5P

Purchased

No

110

Each

0.0000

1

1

110651 DAS 32 9-89

Side Pod, Base 350

D2204-9

Manufactured

No

130

Each

18.0000

5

5

14/10/20 DAS 27 9-89

Rubber Latches

Location Loc Qty Loc Code

st238 18

107654 5

85081 13

D2429-041

Manufactured

No

130

Each

9.0000

1

1

14/10/20 DAS 27 9-89

Spring Clip Ass'y

Location Loc Qty Loc Code

ST010 9

107585 6

81895 3

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

Tuesday, January 07, 2014 3:02:16 PM

Page 3

Work Order ID: 110651

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 1/7/2014

Required Date: 2/21/2014

Start Qty: 1.00

Required Qty: 1.00

D2462 Manufactured No 130 f 262.2300 14.17 15 Seal \$Per Foot

Location Loc Qty Loc Code

ST402 262.23  
98802 262.23

D2528-1 Manufactured No 130 Each 10.0000 5 5 Backer Plate

Location Loc Qty Loc Code

ST011 10  
82334 10

D2528-3 Manufactured No 130 Each 4.0000 4 4 Backer Plate

Location Loc Qty Loc Code

ST011 4  
107611 2  
65085 2

D2569 Manufactured No 130 Each 1.0000 1 1 Hinge

Location Loc Qty Loc Code

CA 1  
107688 1

D3001-1 Manufactured No 110 Each 5.0000 3 3 Doubler

Location Loc Qty Loc Code

ST178 5  
107795 5

D3007-041 Manufactured No 130 Each 2.0000 1 1 Prop Assy

Location Loc Qty Loc Code

ST259 2  
107599 1  
84300 1

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Shop Packet Print

Page 3

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

Tuesday, January 07, 2014 3:02:16 PM

Work Order ID: 110651

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 1/7/2014

Required Date: 2/21/2014

Start Qty: 1.00

Required Qty: 1.00

D3048-1

Doubler

Manufactured No

110 Each 2.0000

1 1

DAS  
32  
9-89

Location

Loc Qty

Loc Code

CA

2

107527

2

MS21042L06

Nut

Purchased No

100 Each 402.0000

2 2

DAS  
27  
9-89  
14/10/20

Location

Loc Qty

Loc Code

ST314

402

m126474

2

m127304

200

m127831

200

MS21042L4

Locknut

Purchased No

130 Each 5,455.0000

20 20

DAS  
27  
9-89  
14/10/20

Location

Loc Qty

Loc Code

GA

80

m126333

80

ST509

4000

m127255

2000

m127813

2000

ST518

1375

m127376

1375

NAS1149D0463J

WASHER

Purchased No

130 Each 1,432.0000

21 21

DAS  
27  
9-89  
14/10/20

Location

Loc Qty

Loc Code

ST510a

1432

M127693

32

M127813

1400

m129890

21

Tuesday, January 07, 2014 3:02:16 PM

Shop Packet Print

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

Tuesday, January 07, 2014 3:02:16 PM

Page 5

Work Order ID: 110651

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 1/7/2014

Required Date: 2/21/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN632J

Purchased

No

130

Each

350.0000

2

2

Washer

DAB

27

1/10/20

## Location

## Loc Qty

## Loc Code

ST293

350

M126084

250

M127255

100

B/28810

2

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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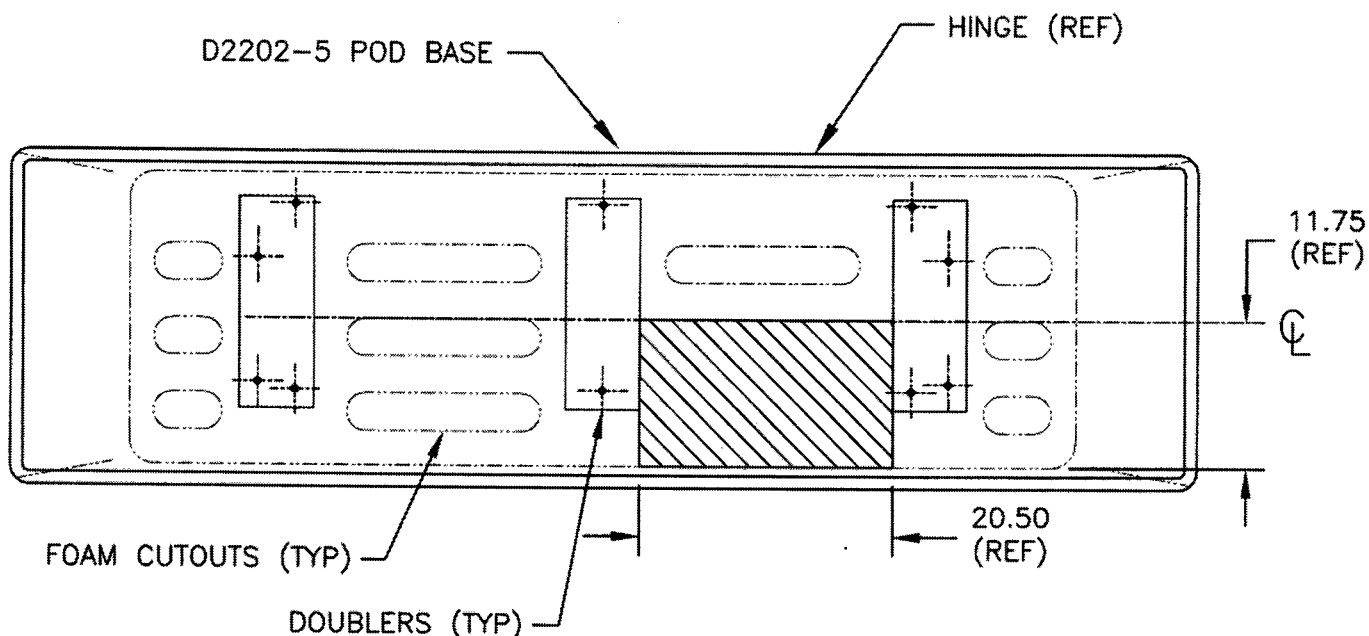
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3322	REV. A SHEET 1 OF 1
DATE 04.09.26		TITLE POD ASSEMBLY	SCALE 1:15
A	04.09.26	NEW ISSUE	

RELEASED  
04.10.29 *[Signature]*

**D3322-041/-042 POD ASSEMBLY**

- 1) THE D3322-041/-042 POD ASSEMBLIES ARE THE SAME AS THE D2694 POD ASSEMBLIES, EXCEPT THE D2202-3 POD BASE IS REPLACED WITH THE D2202-5 POD BASE

*CL 14/01/07*  
*W/O: 110651*



D3322-041 POD ASSEMBLY (SHOWN)  
D3322-042 POD ASSEMBLY (OPPOSITE)

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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Handling/Pre									
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Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
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### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**NOTES:**

## 1) MATERIALS:

RESIN: EPOCAST 50-A/9816,  
OR DERAKANE 470-36/411/510A40

FOAM: A500 CORE CELL,  
OR DIVINYCELL,  
OR AIREX,  
0.38 THICK (3/8 FOAM)

FIBRE: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
5 oz PLAIN WEAVE KEVLAR (5 oz KEVLAR)

2) FINISH: INSIDE = PRIME PER DART QSI 005 4.2  
OUTSIDE = WHITE GELCOAT #GEL 944W005

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) LAMINATE PER DART QSI 006.  
LAMINATION SCHEDULE PER THIS DRAWING.

9) PEEL PLY ALL SURFACES.

CZ 14101107  
W/O. 110651

RELEASED  
2010-10-28  
AR

G	REFORMAT DRAWING TO CURRENT STANDARDS: D2202-101 WAS D2202-1 (ZN C5-2, A4-2); ADD 77.5 & 22.0 DIM. (ZN D4-3, C6-3); D2202-103 WAS D2202-5 (ZN C5-3, A4-3); ADD 2.00 MAX (ZN D3-4); INCORPORATED DEO 9217 & ADD D2202-5/6 ON SHEET 5 PER PAR 09-034	RF	09.10.06
F	CHANGE LAYUP, DOUBLER, NOW DRILLED	CP	01.03.14
E	ADDED SECTIONS WITH LIP DIMS	KE	99.11.11
D	MOVED DOUBLERS, REMOVED HOLES	KE	98.11.09
C	REVISED DOUBLER/HOLES LOCATIONS	KE	97.07.04
B	ADD DOUBLERS AND HOLES	-	93.10.27
A	NEW ISSUE	-	93.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 1 OF 5
APPROVED	14	TITLE	SCALE
DE APPR.	14	UTILITY POD LID AND BASE	NTS
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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

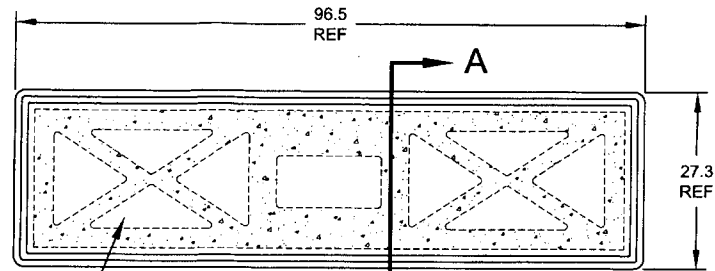
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

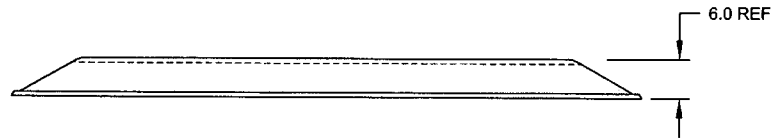
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other    
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SEE  
DETAIL B  
A6-2

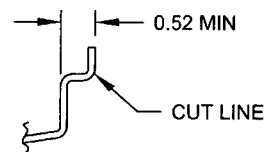
**SECTION A-A** C3-2



**G**  
D2202-101 FOAM CORE,  
MAKE FROM 3/8" FOAM, ROUTER PER DT8024



**D2202-1 LID**  
(MOLD DT8002)



**DETAIL B**  
SCALE 10X D6-2

**MAIN LAYUP**

9oz SATIN  
9oz SATIN  
5oz KEVLAR  
**G** D2202-101 FOAM CORE  
5oz KEVLAR  
9oz SATIN

**RELEASED**  
R 2010-10-28 D

DESIGN	KE	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 2 OF 5
APPROVED	JP	TITLE	SCALE
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## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

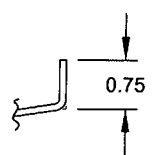
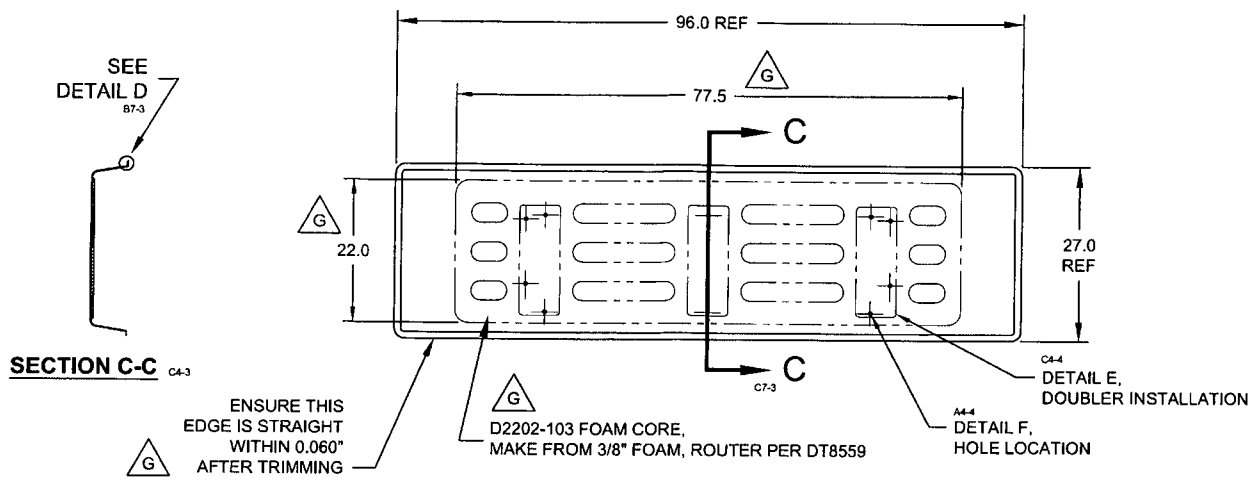
### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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8 7 6 5 4 3 2 1

D  
C  
B  
A

D  
C  
B  
A



**DETAIL D**  
SCALE 10X  
D7-3



**D2202-3 BASE**  
(MOLD DT8002)

- MAIN LAYUP**
- 9oz SATIN
  - 9oz SATIN
  - 5oz KEVLAR
  - D2202-103 FOAM CORE
  - 5oz KEVLAR
  - 5oz KEVLAR
  - 9oz SATIN

**RELEASED**  
2010-10-28

DESIGN	KE	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	47	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 3 OF 5
APPROVED	147	TITLE	SCALE
DE APPR.	147	UTILITY POD LID AND BASE	NTS
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8 7 6 5 4 3 2 1

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

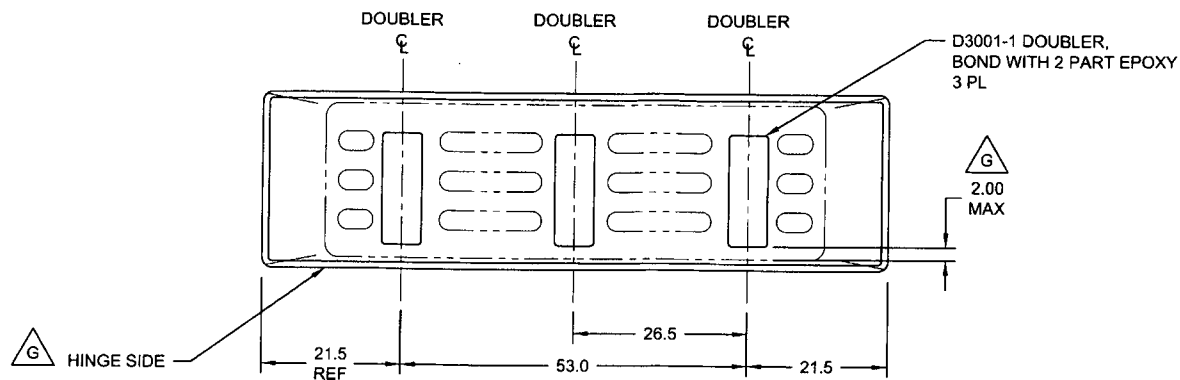
Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

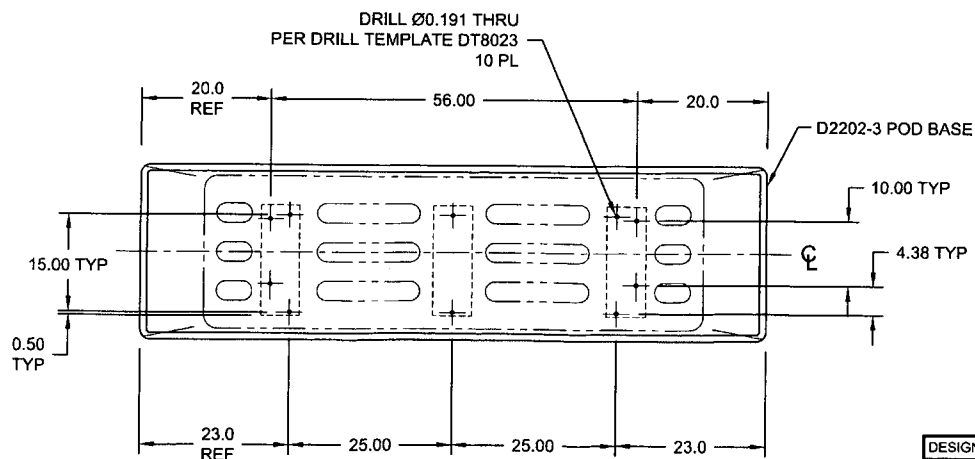
### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**DETAIL E: INSTALLATION OF D3001-1 DOUBLERS** C3-3



**DETAIL F: HOLE DRILLING** C3-3  
(AFTER DOUBLER INSTALLATION)

**RELEASED**  
R 2010-10-28

DESIGN	KE	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 4 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

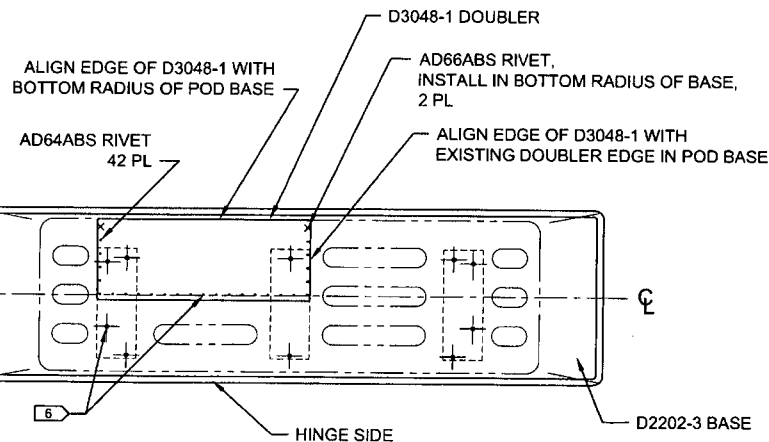
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**NOTES : TO MAKE A D2202-5/6 BASE (FOR D350-602-013/-014) FROM A D2202-3 BASE**

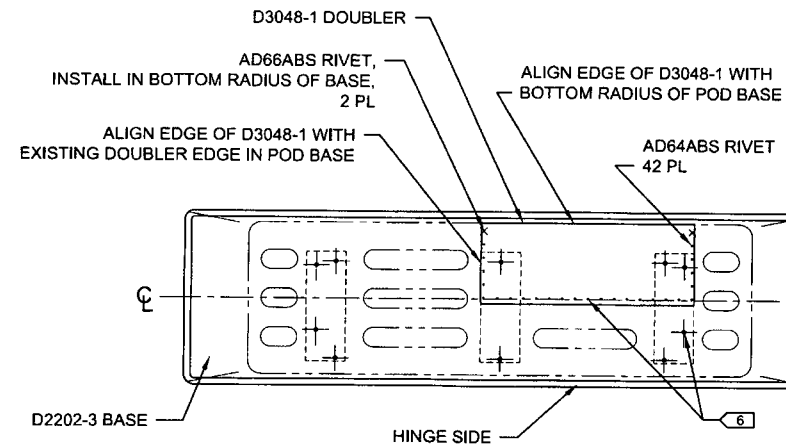
- 1) REMOVE FOAM IN AREA OF POD BASE WHERE D3048-1 DOUBLER WILL BE INSTALLED
- 2) FILL GAPS WITH 9oz SATIN AND RESIN PER DWG (APPROX. 3-4 LAYERS)
- 3) 2 LAYERS OF 9oz SATIN
- 4) BOND D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) TRANSFER Ø0.125 HOLES FROM D3048-1 TO POD BASE. INSTALL DOUBLER WITH AD64ABS RIVETS (42) AND AD66ABS (2)
- 6) TRANSFER Ø0.191 HOLES FROM POD BASE TO D3048-1. SEAL HOLES WITH CYANOACRYLATE GLUE
- 7) TOUCH UP AFFECTED AREA WITH GREY PRIMER PER DWG
- 8) FILL CENTER OF THE AD RIVETS WITH RTV 732 TO SEAL

**PART LIST:**

QTY -5	QTY -6	PART NUMBER	DESCRIPTION
X		D2202-5	POD BASE
	X	D2202-6	POD BASE
1	1	D2202-3	BASE
1	1	D3048-1	DOUBLER
42	42	AD64ABS	RIVET
2	2	AD66ABS	RIVET
A/R	A/R	RTV	SEALANT



**D2202-5 BASE: D3048-1 DOUBLER INSTALLATION**  
(MAKE FROM D2202-3 BASE)



**D2202-6 BASE: D3048-1 DOUBLER INSTALLATION**  
(MAKE FROM D2202-3 BASE)

DESIGN	KE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 5 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO22543**

Purchase Order Date 1/8/2014

PO Print Date 1/8/2014

Page Number 1 of 1

Order From :  
DELASTEK INC  
2699 SE AVENUE, LOCAL C.P 10100  
  
GRAND-MERE, QC G9T 5K7  
CA

VU-DEL003

Ship To : DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
10/14/13

Contact Name  
Vendor Phone 819 533 5788  
  
Ship To Contact  
Ship To Phone  
Ship Via: TST ground  
Ship Acct:

Buyer  
Customer POID  
Customer Tax # 10127-2607  
Terms Net 30  
Currency USD  
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2202-1P  AS PER DWG D2202 REV.G B110651	Side Pod Lid, 350	2/21/2014 Yes 2/21/2014		1.00 Each	\$2,890.60	\$2,890.60
Line Total:							\$2,890.60
2	D2202-5P  AS PER DWG D2202 REV. G B110651	Side Pod, Base 350	2/21/2014 Yes 2/21/2014		1.00 Each	\$2,890.60	\$2,890.60
Line Total:							\$2,890.60
PO Total:							\$5,781.20

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.  
No substitution or deviation without consent.  
Certificate of Conformity or Material Certification required **YES** NO  
PST# 6122-5207

Change Nbr:

1

Change Date: 1/8/2014



DELASTEK Inc.  
2699 5e Avenue  
Local 14,  
Grand-Mère, Québec G9T 2P7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

# PACKING SLIP

## CERTIFICATE OF COMPLIANCE

Invoice No.	50525
Customer No.	DART US

### Bill To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

### Ship To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
13-02-2014	08-01-2014	24201	Chantal Lavoie	22543	Net 30 days USA
Ship Via		F.O.B.	Salesperson		GST/PST
TST Overland Express #		Point de départ	MP MONTAMBEAULT ext 235		
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0073	Line 1 D2202-1 Side Pod Lid Référence DKA362-0015 DWG: REV. G <div style="text-align: right;">Lot # 58761</div>	U of M: Chaque 1
1	0	1	DKC134-0075	Line 2 D2202-5 Side Pod Base DWG: D2202 Rév.: G <div style="text-align: right;">Lot # 58762</div>	U of M: Chaque 1

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request*

Accepted by:

Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Jeudi, 2014-01-09 07:39:32  
Utilisateur: marc dubé

## Feuille de Procédé

<b>Client</b> : DART US DART AEROSPACE <b>Numéro Job</b> : 58762 <b>Numéro</b> : 4345 <b>Numéro B.A.</b> : <b>Cette fois</b> : 2014-01-09 <b>No.</b> : <b>Prsht Rev.</b> : NC <b>Prem. fois</b> : - - <b>Type</b> : <b>Job précédente</b> : 56327 <b>Écrit par</b> : _____ <b>Vérifié &amp; Approuvé par</b> : _____ <b>Commentaires</b> : N° de Pièce Client: D2202-5	<b>Nom Dessin</b> : UTILITY POD BASE <b>Numéro Article</b> : DKC134-0075 <b>Numéro Dessin</b> : D2202 <b>Projet Numéro</b> : DK-362 <b>Révision dessin</b> : G <b>Matériel</b> : Resine Darakane 470-36/411/510 <b>Date Due</b> : 2014-01-16 <b>Qté:</b> 1 Ud UNITE
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COPIE

Process Sheet Rév.: 02 AAC1885 était AC0883,  
AAC1887 était AC0884

### Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
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1.0	AAC1616	N° 83634, Frekote Loctite Wolo
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**Comment** Qty.: 0.030 UNITE(s)/Unit Total : 0.030 UNITE(s)  
N° 83634, Frekote Loctite Wolo # de Lot: 1-42289-1

2.0	PREP-GENERAL	Préparation du matériel
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**Comment** Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule DKO-0331 selon IF134-0011.

Date: 23/01/14 Sceau: \_\_\_\_\_



3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
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**Comment** Qty.: 1.250 KILOGRAMME(s)/Unit Total : 1.250 KILOGRAMME(s)  
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-44240-1

4.0	AMB0286	Catalyst N° DDM-9
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**Comment** Qty.: 0.0095 GALLON(s)/Unit Total : 0.0095 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

5.0	GEL COAT	Application du Gel Coat
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**Comment** Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Appliquer le Gel Coat sur le moule selon IF134-0011.









Date: 23/01/14 Sceau: \_\_\_\_\_



Date: Jeudi, 2014-01-09 07:39:32

Utilisateur: marc dubé

## Feuille de Procédé













<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> UTILITY POD BASE	
<b>Numéro Job:</b> 58762	<b>Numéro</b> DKC134-0075	
<b>Numéro Job:</b> 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
6.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
<b>Comment</b> Qty.: 9.90 VERGE(s)/Unit Total: 9.90 VERGE(s) 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-43410-1		
7.0	AAC1885	Tissu à délaminer Release ply B
<b>Comment</b> Qty.: 9.16 VERGE(s)/Unit Total: 9.16 VERGE(s) Tissu à délaminer Release ply B # de Lot: N/A		
8.0	AAC1608	5oz plain weave Kevlar 50" wide roll
<b>Comment</b> Qty.: 6.60 VERGE(s)/Unit Total: 6.60 VERGE(s) 5oz plain weave Kevlar 50" wide roll N° de Lot: 1-42765-1		
9.0	AAC1887	Wrightlon 5200 Bleu P3
<b>Comment</b> Qty.: 14.95 VERGE(s)/Unit Total: 14.95 VERGE(s) Wrightlon 5200 Bleu P3 # de Lot: N/A		
10.0	AC0885	Feutre de drainage N° Airweave N 10
<b>Comment</b> Qty.: 12.50 VERGE(s)/Unit Total: 12.50 VERGE(s)		
11.0	AC0943	Stretchlon 200 poche à vide Vert
<b>Comment</b> Qty.: 42.63 PIED(s)/Unit Total: 42.63 PIED(s)		
12.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
<b>Comment</b> Qty.: 3.0000 ROULEAU(s)/Unit Total: 3.0000 ROULEAU(s)		
13.0	AC1091	Film durisol # 3001792
<b>Comment</b> Qty.: 12.50 METRE CAR(s)/Unit Total: 12.50 METRE CAR(s)		
14.0	TAILLAGE	Faire le taillage du matériel
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire le taillage du matériel et le matériel pour le Bagging selon IF 134-0011. Date: 10-01-14 Sceau: 		
15.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
<b>Comment</b> Qty.: 2.500 KILOGRAMME(s)/Unit Total: 2.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-44165-1		
16.0	AMB0286	Catalyst N° DDM-9
<b>Comment</b> Qty.: 0.0845 GALLON(s)/Unit Total: 0.0845 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-27829-1		
17.0	LAMINAGE	Faire le laminage
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire le laminage des tissus(verre et Kevlar) selon IF 134-0011. Date: 23/01/14 Sceau:  		



Date: Jeudi, 2014-01-09 07:39:32

Utilisateur: marc dubé















## Feuille de Procédé

<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> UTILITY POD BASE	
<b>Numéro Job:</b> 58762	<b>Numéro</b> DKC134-0075	
Numéro Job: 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
18.0	BAGGING	Faire le bagging sur la pièce
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire la poche à vide selon IG 0012.		
Laisser sécher pendant 4 heures minimum.		
Heure début Curing: 12:30 Heure Fin Curing: 8:00		
Date: 23/01/14 Sceau:  		
19.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
<b>Comment</b> Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s)		
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-44165-1		
20.0	AMB0286	Catalyst N° DDM-9
<b>Comment</b> Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s)		
Catalyst N° DDM-9 N° de Lot: 1-27829-1		
21.0	DKC134-0021	D2202-103 Foam Core ( Utility pod Base )
<b>Comment</b> Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)		
D2202-103 Foam Core ( Utility pod Base ) N° de Job: 58763		
22.0	PREP-GENERAL	Préparation du matériel
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run.: 0.0000Hrs		
Sceller le Foam Core N° DKC134-0021 selon IG 0105.		
Date: 13/01/14 Sceau:  		
23.0	AAC1611	Polybond B46F
<b>Comment</b> Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s)		
Polybond B46F N° de Lot: 1-40397-1		
24.0	ASSEMBLAGE	Assemblage mécanique
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Positionner et coller le Foam Core N° DKC134-0021 selon IF134-0011.		
Date: 24-01-13 Sceau: 		

Date: Jeudi, 2014-01-09 07:39:32

Utilisateur: marc dubé

## Feuille de Procédé

<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> UTILITY POD BASE	
<b>Numéro Job:</b> 58762	<b>Numéro</b> DKC134-0075	
Numéro Job: 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
25.0	BAGGING	Faire le bagging sur la pièce
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire la poche à vide selon IG 0012.		
Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.		
Heure début Curing: <u>10:35</u> Heure Fin Curing: <u>11:25</u>		
Date: <u>29-01-14</u> Sceau: 		
26.0	DECOUPE	Découpe manuelle des pièces
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire la découpe manuelle du foamcore selon IF134-0011 point 8.5.		
Date: <u>29/01/14</u> Sceau:  		
27.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
<b>Comment</b> Qty.: 2.500 KILOGRAMME(s)/Unit Total: 2.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-44165-1</u>		
28.0	AMB0286	Catalyst N° DDM-9
<b>Comment</b> Qty.: 0.0845 GALLON(s)/Unit Total: 0.0845 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
29.0	LAMINAGE	Faire le laminage
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire le laminage des derniers tissus selon IF134-0011.		
Date: <u>29/01/14</u> Sceau: <u>4102 N.T.</u>  		
30.0	BAGGING	Faire le bagging sur la pièce
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire la poche à vide selon IG 0012.		
Laisser sécher pendant 4 heures minimum.		
Heure début Curing: <u>10:30</u> Heure Fin Curing: <u>8:00</u>		

Date: Jeudi, 2014-01-09 07:39:32

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD BASE

Numéro Job: 58762

Numéro DKC134-0075

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Date: 29/01/14 Sceau: 4102 N.T.



31.0 AAC1615 D3001-1 Doubler ( Pod Base D2002-3)

Comment Qty.: 3 UNITE(s)/Unit Total: 3 UNITE(s)

D3001-1 Doubler ( Pod Base D2002-3)

N° de Lot: L-44313-1

32.0 AAC0102 Colle Araldite N° 2012 (50ml)

Comment Qty.: 0.50 UNITE(s)/Unit Total: 0.50 UNITE(s)

Colle Araldite N° 2012 (50ml)

N° de Lot: 1-43407-2

33.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller les trois doublers N° D3001-1 selon IF134-0011.

Faire trois petites poches à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum. selon IG0058

Heure début Curing: 11:30

Heure Fin Curing: 12:50

Date: 30/01/14 Sceau:



30 jan 2014



34.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.030 GALLON(s)/Unit Total: 0.030 GALLON(s)

N° P-15-3, Adtech Micro Ultra Filler

# de Lot: 1-43091-1

35.0 FINITION Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Retirer les trois poches à vide et faire un joint tout autour des trois doublers à l'aide du "Filler" P15-3 et laisser sécher.

Date: 31/01/14 Sceau:



36.0 AAC1680 D3048-1 Doubler

Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

D3048-1 Doubler

N° de Lot: 1-44313-2

37.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des tissus pour épaissir et installer le grand doubler selon IF134-0011.

Date: Jeudi, 2014-01-09 07:39:32

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD BASE

Numéro Job: 58762

Numéro DKC134-0075

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Date: 30/01/14 Sceau:



38.0 AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.060 GALLON(s)/Unit Total : 0.060 GALLON(s)  
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-43091-1

39.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la finition de l'intérieur selon IG 0043.

Vérifier la surface intérieure du Pod et injecter à l'aide d'une seringue munit d'une aiguille de la résine aux endroits où il y a des bulles d'air.

Corriger les imperfections de surface à l'aide du "Filler" P15-3.

Laisser sécher jusqu'au lendemain.

Date: 31/01/14 Sceau:



40.0

DÉMOULAGE

Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le démoulage du Utility Pod Base en faisant bien attention de ne pas endommager la pièce.

Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide d'un manche de tournevis.

Date: 31/01/14 Sceau:



41.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le trimage selon IF134-0012.










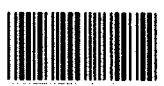




Date: 31/01/14 Sceau:



Date: Jeudi, 2014-01-09 07:39:32

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: UTILITY POD BASE	
Numéro Job: 58762		Numéro: DKC134-0075	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
42.0	AAC1021	Dupont Primer N° 7704S	
<b>Comment</b> Qty.: 0.4333 UNITE(s)/Unit Total : 0.4333 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-43946-3</u>			
43.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
<b>Comment</b> Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-44063-3</u>			
44.0	PRÉPARATION.	Préparation du matériel	
			
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs Préparer la pièce selon IG 0008.			
Date: _____ Sceau: _____		 3/10/2014 	
45.0	PRIMER	Application primer	
			
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer le primer selon IG 0008.			
Date: <u>4/02/14</u> Sceau: 		# de Fiche technique: <u>6546</u>	
46.0	FINITION	Finition Générale	
			
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Ponçer le "Primer" batisseur selon IG 0008.			
Date: <u>05-02-14</u> Sceau: 			
47.0	AAC1021	Dupont Primer N° 7704S	
<b>Comment</b> Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-43178-2</u>			
48.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
<b>Comment</b> Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-44063-3</u>			
49.0	PRIMER	Application primer	
			
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer le primer selon IG 0008.			
Date: <u>6/02/14</u> Sceau: 			

Date: Jeudi, 2014-01-09 07:39:32

Utilisateur: marc dubé

## Feuille de Procédé

<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> UTILITY POD BASE
<b>Numéro Job:</b> 58762	<b>Numéro</b> DKC134-0075

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

50.0

INSPEC FINAL

Inspection finale



**Comment** Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date:

6/1/14

Sceau:



51.0

EMBAL / ENTREPO

Emballage & Entreposage



**Comment** Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057.

Date:


FEB 07 2014

Sceau:



Date: Jeudi, 2014-01-09 07:39:32  
Utilisateur: marc dubé

## Feuille de Procédé

<b>Client</b> :	DART US DART AEROSPACE	<b>Nom Dessin</b> :	UTILITY POD LID
<b>Numéro Job</b> :	58761	<b>Numéro Article</b> :	DKC134-0073
<b>Numéro</b> :	4347	<b>Numéro Dessin</b> :	D2202
<b>Numéro B.A.</b> :		<b>Projet Numéro</b> :	DK-362
<b>Cette fois</b> :	2014-01-09	<b>Révision dessin</b> :	G
<b>Prsht Rev.</b> :	NC	<b>Matériel</b> :	Resine Darakane 470-36/411/510
<b>Prem. fois</b> :	- -	<b>Date Dûe</b> :	2014-01-16
<b>Job précédente</b> :	58201	<b>Qté:</b>	1 Ud UNITE
<b>Écrit par</b> :			
<b>Vérifié &amp; Approuvé par</b> :			
<b>Commentaires</b> :	N° de Pièce Client: D2202-1		

Process Sheet Rév.: 03 Ajout de la IF134-0008 à la séquence 35.0.

COPIE

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
---------	------------	---------------

1.0	AAC1616	N° 83634, Frekote Loctite Wolo
-----	---------	--------------------------------

**Comment** Qty.: 0.030 UNITE(s)/Unit Total : 0.030 UNITE(s)  
N° 83634, Frekote Loctite Wolo # de Lot: 1-42289-1

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



**Comment** Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DT8002 selon IG 0009.

Date: 17/01/14 Sceau:



3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

**Comment** Qty.: 1.250 KILOGRAMME(s)/Unit Total : 1.250 KILOGRAMME(s)  
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-94240-1

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

**Comment** Qty.: 0.0095 GALLON(s)/Unit Total : 0.0095 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

5.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



**Comment** Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Appliquer le gel coat selon IG 0019.

Date: 17/01/14 Sceau:



Date: Jeudi, 2014-01-09 07:39:32

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD LID

Numéro Job: 58761

Numéro DKC134-0073

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

6.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
-----	---------	---

Comment Qty.: 9.90 VERGE(s)/Unit Total : 9.90 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-43410-1

7.0	AAC1885	Tissu à délaminer Release ply B
-----	---------	---------------------------------

Comment Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s)

Tissu à délaminer Release ply B # de Lot: B000242

8.0	AAC1608	5oz plain weave Kevlar 50" wide roll
-----	---------	--------------------------------------

Comment Qty.: 6.60 VERGE(s)/Unit Total : 6.60 VERGE(s)

5oz plain weave Kevlar 50" wide roll N° de Lot: 1-42265-1

9.0	AAC1887	Wrightlon 5200 Bleu P3
-----	---------	------------------------

Comment Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s)

Wrightlon 5200 Bleu P3 # de Lot: N/A

10.0	AC0885	Feutre de drainage N° Airweave N 10
------	--------	-------------------------------------

Comment Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)

11.0	AC0943	Stretchlon 200 poche à vide Vert
------	--------	----------------------------------

Comment Qty.: 42.63 PIED(s)/Unit Total : 42.63 PIED(s)

12.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Comment Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)

13.0	TAILLAGE	Faire le taillage du matériel
------	----------	-------------------------------

Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le taillage du matériel selon les Dimensions requises:

Un morceau pour recouvrir le fond du moule N° DT8002.

Deux morceaux pour couvrir les extrémités du moule N° DT8002.

Deux morceaux pour recouvrir les cotés du moule N° DT8002.

Faire cette opération pour les trois plis de 9 oz ainsi que pour les deux plis de 5 oz de Kevlar.

Tailler le matériel nécessaire pour la poche à vide ( Faire 3 kits car il y aura trois baggings différents lors de la fabrication de cette pièce):

Peel Ply

Film Durisol P-3

Feutre de drainage 6m

Stretchlon 200

Coller une bande de ruban jaune tout le tour du Stretchlon 200, plier les différentes composantes des poches à vide et entreposer en attente des opérations de bagging.



Date: Jeudi, 2014-01-09 07:39:32

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD LID

Numéro Job: 58761

Numéro DKC134-0073

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Date: 16/01/14



14.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-44165-1

15.0 AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

16.0 PREP-GENERAL

Préparation du matériel

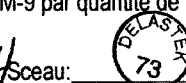


Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Mélanger la quantité de résine désirée pour le laminage des trois premier plis du Pod Lid :

1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 Min.

Date: 17/01/14



17.0 LAMINAGE

Faire le laminage



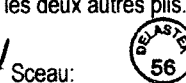
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des trois premiers plis de tissu ( 2 plis de 9 oz et 1 pli de 5 oz Kevlar )  
de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350  
Promoté 75 Minutes, ensuite venir laminer un pli de 9 oz dans le fond du moule, suivre  
avec les deux extrémités et terminer avec les deux cotés. ( Ajouter de la résine au besoin  
)

Recommencer pour les deux autres plis. ( un pli de 9 oz et un pli de 5 oz Kevlar )

Date: 17/01/14



18.0 BAGGING

Faire le bagging sur la pièce

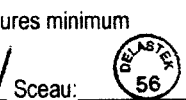


Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher 4 heures minimum
















Date: 17/01/14



Date: Jeudi, 2014-01-09 07:39:32

Utilisateur: marc dubé












## Feuille de Procédé

<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> UTILITY POD LID	
<b>Numéro Job:</b> 58761	<b>Numéro</b> DKC134-0073	
Numéro Job: 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
19.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
<b>Comment</b>	Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-44165-1</u>	
20.0	AMB0286	Catalyst N° DDM-9
<b>Comment</b>	Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>	
21.0	DKC134-0022	D2202-101 Foam Core ( Utility Pod Lid )
<b>Comment</b>	Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) D2202-101 Foam Core ( Utility Pod Lid ) N° de Job: <u>58764</u>	
22.0	PREP-GENERAL	Préparation du matériel
 		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Faire un mélange de résine Derakane 411-350 Promoté 15 à 18 Minutes 1.5% de catalyst DDM-9 par quantité de résine. Date: <u>13/01/14</u> Sceau:  	
23.0	ASSEMBLAGE	Assemblage mécanique
 		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Sceller le Foam Core N° DKC134-0022 selon IG 0105. Date: <u>13/01/14</u> Sceau:  	
24.0	AAC1611	Polybond B46F
<b>Comment</b>	Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s) Polybond B46F N° de Lot: <u>1-40597-1</u>	
25.0	ASSEMBLAGE	Assemblage mécanique
 		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Faire l'assemblage du Foam Core N° DKC134-0022 à l'aide du polybond 46F selon IG 0033. Date: <u>20/01/14</u> Sceau:  	
26.0	BAGGING	Faire le bagging sur la pièce
 		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Faire la poche à vide selon IG 0012.	

Date: Jeudi, 2014-01-09 07:39:32

Utilisateur: marc dubé













## Feuille de Procédé

<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> UTILITY POD LID	
<b>Numéro Job:</b> 58761	<b>Numéro:</b> DKC134-0073	
Numéro Job: 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
<p>Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.</p> <p>Heure début Curing: <u>9:00</u> Heure Fin Curing: <u>10:25</u></p> <p>Date: <u>20/01/14</u> sceau:  </p>		
27.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
<b>Comment</b>	Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-44165-1</u>	
28.0	AMB0286	Catalyst N° DDM-9
<b>Comment</b>	Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>	
29.0	PREP-GENERAL	Préparation du matériel
 		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs	
<p>Mélanger la quantité de résine désirée pour le laminage des deux derniers plis du Pod Base: 1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 minutes.</p> <p>Date: <u>22/01/14</u> Sceau:  </p>		
30.0	LAMINAGE	Faire le laminage
 		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs	
<p>Faire le laminage des deux dernier plis de tissu ( 1 plis de 5 oz Kevlar et 1 pli de 9 oz) de la façon suivante:</p> <p>Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 minutes, ensuite venir laminer un pli de 5 oz Kevlar dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. ( Ajouter de la résine au besoin )</p> <p>Recommencer pour le dernier plis. ( un pli de 9 oz )</p> <p>Date: <u>22/01/14</u> Sceau:  </p>		

Date: Jeudi, 2014-01-09 07:39:32

Utilisateur: marc dubé














## Feuille de Procédé

<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> UTILITY POD LID	
<b>Numéro Job:</b> 58761	<b>Numéro</b> DKC134-0073	
Numéro Job: 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
31.0	BAGGING	Faire le bagging sur la pièce
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire la poche à vide selon IG 0012.		
Laisser sécher 4 heures minimum.		
Heure début Curing: <u>8:30</u> Heure Fin Curing: <u>8:00</u>		
Date: <u>22/01/14</u> Sceau:  		
32.0	DÉMOULAGE	Démoulage de la pièce
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire le démoulage du Utility Pod Lid en faisant bien attention de ne pas endommager la pièce		
Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide du manche d'un tournevis		
Date: <u>23/01/14</u> Sceau:  		
33.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler
<b>Comment</b> Qty.: 0.060 GALLON(s)/Unit Total : 0.060 GALLON(s)		
N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-43091-1</u>		
34.0	FINITION	Finition Générale
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Sabler légèrement toute la surface intérieur du pod à l'aide de papier sablé grit 120.		
Vérifier la surface intérieur du pod et injecter à l'aide d'une seringue munit d'une aiguille de la résine au endroit où il y a des bulles d'air.		
Corriger les imperfection de surface à l'aide du "Filler" P15-3 selon IG 0043		
Laisser sécher jusqu'au lendemain.		
Date: <u>27/01/14</u> Sceau: 		

Date: Jeudi, 2014-01-09 07:39:32

Utilisateur: marc dubé

## Feuille de Procédé

<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> UTILITY POD LID	
<b>Numéro Job:</b> 58761	<b>Numéro</b> DKC134-0073	
Numéro Job: 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
35.0	TRIMAGE	Trimage
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire le trimage du Pod Lid selon la IF134-0008.		
Date: <u>23/01/14</u> Sceau: 		
36.0	AAC1021	Dupont Primer N° 7704S
<b>Comment</b> Qty.: 0.4300 UNITE(s)/Unit Total : 0.4300 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-49946-3</u>		
37.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
<b>Comment</b> Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>2-44063-3</u>		
38.0	PRIMER	Application primer
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008		
Date: <u>30/01/14</u> Sceau:  # Fiche de Mélange: <u>6843</u>		
39.0	FINITION	Finition Générale
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire le sablage au grit 180 de la surface primée pour enlever les imperfections restantes.		
Date: <u>31/01/14</u> Sceau: 		
40.0	AAC1021	Dupont Primer N° 7704S
<b>Comment</b> Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-43946-3</u>		
41.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
<b>Comment</b> Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-44063-3</u>		
42.0	PRIMER	Application primer
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008		
Date: <u>4/02/14</u> Sceau:  # Fiche de Mélange: <u>6546</u>		

Date: Jeudi, 2014-01-09 07:39:32  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 58761

Nom Dessin: UTILITY POD LID  
Numéro: DKC134-0073

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

43.0

INSPEC FINAL

Inspection finale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 6 Feb 14

Sceau:



44.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057

Date:

FEB 07 2014

Sceau:



**DELASTEK**

DELASTEK Inc.  
2699 5e Avenue  
Local 14,  
Grand-Mère, Québec G9T 2P7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

# PACKING SLIP

## CERTIFICATE OF COMPLIANCE

Invoice No.	50525
Customer No.	DART US

**Bill To**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200


Contact : Linda Lacelle

**Ship To**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200


Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
13-02-2014	08-01-2014	24201	Chantal Lavoie	22543	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
TST Overland Express #	Point de départ	Marie-Pier Montambeault, 235			
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0073 ✓	Line 1 D2202-1 Side Pod Lid Référence DKA362-0015 DWG: REV. G Lot # 58761	U of M: Chaque 1
1	0	1	DKC134-0075 ✓	Line 2 D2202-5 Side Pod Base DWG: D2202 Rév.: G Lot # 58762	U of M: Chaque 1
DAY & ROSS DRM1788298 EXP-13-FEV-2014 					
2014-3-12.					

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Mathieu Byth  
Quality department  
AQ-357



☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO22543**

Purchase Order Date 1/8/2014

PO Print Date 3/6/2014

Page Number 1 of 2

Order From :  
DELASTEK INC  
2699 5E AVENUE, LOCAL C.P 10100  
  
GRAND-MERE, QC G9T 5K7  
CA

VU-DEL003

Ship To : DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

RECEIVED  
20

Contact Name  
Vendor Phone 819 533 5788  
  
Ship To Contact  
Ship To Phone  
Ship Via: TST ground  
Ship Acct:

Buyer  
Customer POID  
Customer Tax # 10127-2607  
Terms Net 30  
Currency USD  
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2202-1P  AS PER DWG D2202 REV.G B110651	Side Pod Lid, 350	2/21/2014 Yes 2/21/2014		1.00 Each ✓	\$2,890.60	\$2,890.60
Line Total:							\$2,890.60
2	D2202-5P  AS PER DWG D2202 REV. G B110651	Side Pod, Base 350	2/21/2014 Yes 2/21/2014		1.00 Each ✓	\$2,890.60	\$2,890.60
Line Total:							\$2,890.60
3	72050-20	REPAIR COST D2202-1	2/21/2014 Yes 2/21/2014		1.00 Each ✓	\$720.00	\$720.00

Note:

SP 14-3-12

3/6/2014



Qty	Part Number	Description
X	D2694	UTILITY POD ASSEMBLY
1	D2202-1	POD LID
1	D2202-3	POD BASE
5	D2204-9	LATCH
1	D2429-041	SPRING CLIP ASSEMBLY
1	D2461-1700	NEOPRENE SEAL
5	D2528-1	BACKER PLATE
4	D2528-3	BACKER PLATE
1	D2569	HINGE
1	D3007-041	PROP ASSEMBLY
19	AN4-5A	BOLT
1	AN4-6A	BOLT
2	AN526C632R7	SCREW
21	AN960JD416	WASHER
2	AN960JD6	WASHER
2	MS21042L06	NUT (OR MS21042-06)
20	MS21042L4	NUT (OR MS21042-4)
38	AD62ABS	RIVET

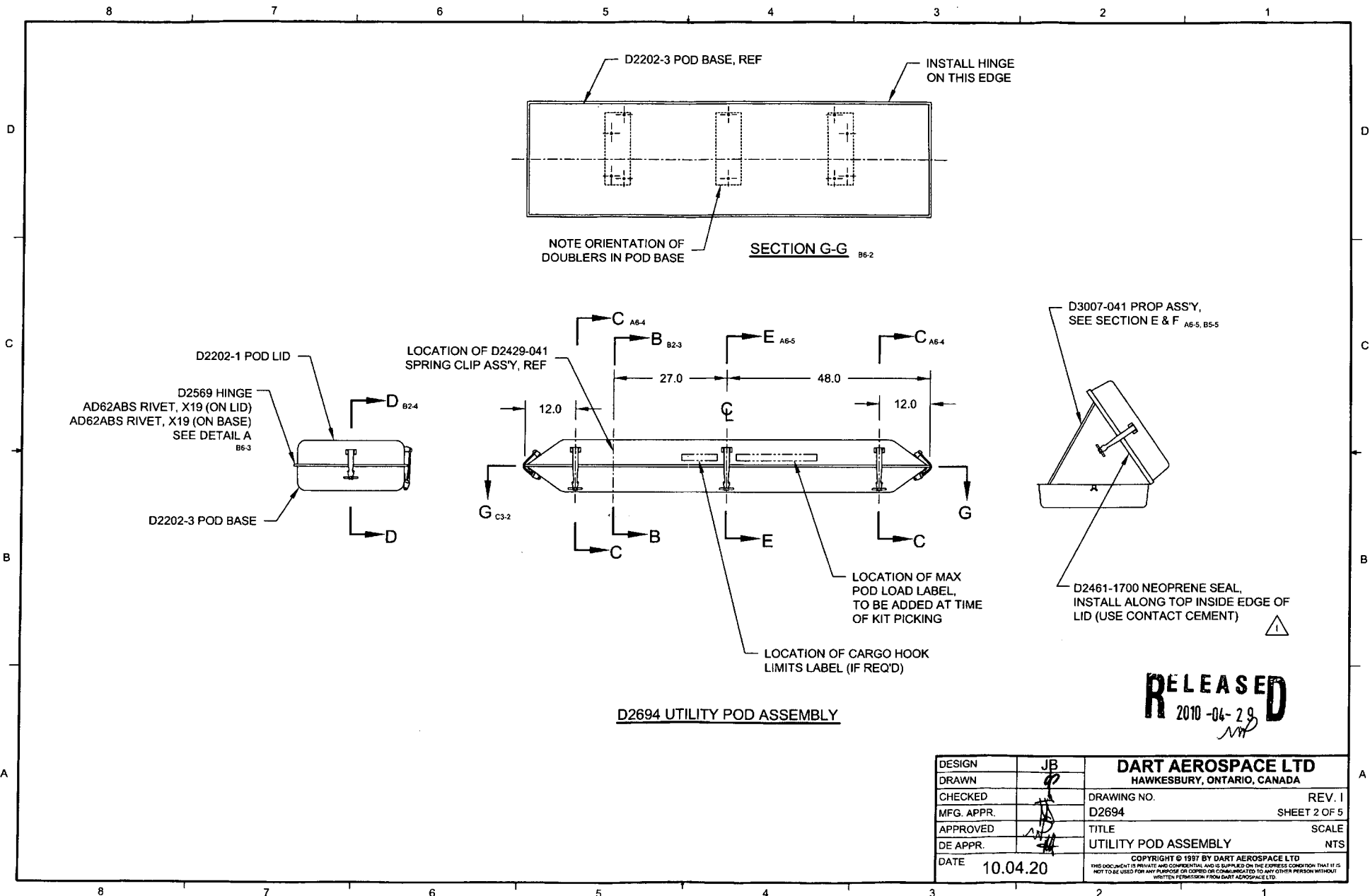
# **GENERAL NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER QSI 005 4.2 TO MATCH ORIGINAL FINISH  
AS REQ'D TO TOUCH UP FINISH AFTER DRILLING OR ASSEMBLY  
INSIDE: DUPONT HIGHBUILD PRIMER GREY 1144-S  
OR DUPONT 2K-URETHANE PRIMER GREY 7704-S  
OUTSIDE: DUPONT IMRON POLYURETHANE ENAMEL BASE WHITE (555U)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 48.5 lbs
- 8) TRANSFER DRILL UNSPECIFIED HOLES FROM ATTACHING PART AS FOLLOWS: AN526C632 → DRILL Ø0.141  
AN4 → DRILL Ø0.257
- 9) SEAL ALL HOLES AND EDGES OF POD WITH CYANOACRYLATE GLUE
- 10) FOR D2569 HINGE:
  - (i) INSTALL RIVET HEADS FROM OUTSIDE OF POD
  - (ii) GRIND TRAILING EDGE OF RIVET TO PERMIT HINGE TO CLOSE
  - (iii) ENSURE ALL RIVET HOLES ARE DRILLED ON THE LARGER HINGE TABS AS SHOWN IN DETAIL A

I	REFORMAT, D2204-9 LOC SPEC'D (B2-4,B6-4,C2-4,C6-4, B6-5,C6-5), D2461-X WAS D2462-X (D5-1,B1-2), ADD FINISH (B5-1)	CP	10.04.20
H	CHANGED RIVETS FROM AD64ABS TO AD62ABS (PAR#185)	DC	07.07.18
G	REVERT BACK TO D2204-9 LATCH	CP	01.05.08
F	REDESIGN, CHANGE LATCHES & PROP	CP	01.03.20
E	CHANGE DIMENSIONS	RF	99.12.20
D	SEAL & HINGE CHANGE (TSR A1047 & A855/A858); INCLUDED DE09119	CP	99.01.08
C	ADD DOUBLER HOLES, REMOVE FINISH	KE	98.11.12
B	CHANGE RIVET PATTERN, ADD D2429	KE	97.10.08
A	NEW ISSUE CREATED TO REPLACE D350-602-041 AND -043	KE	97.07.02
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D2694	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
DATE	10.04.20	COPYRIGHT © 1997 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT ITS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. 1
MFG. APPR.	<i>[Signature]</i>	D2694	SHEET 2 OF 5
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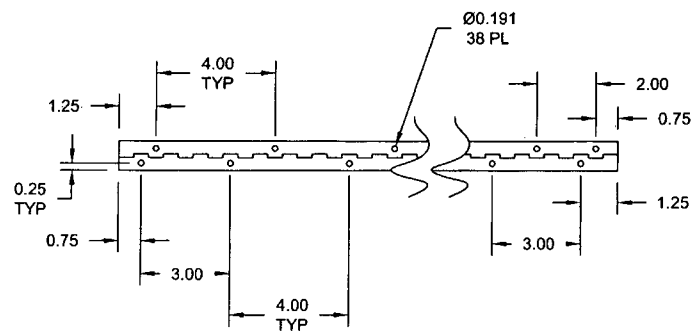
8 7 6 5 4 3 2 1

D

C

B

A



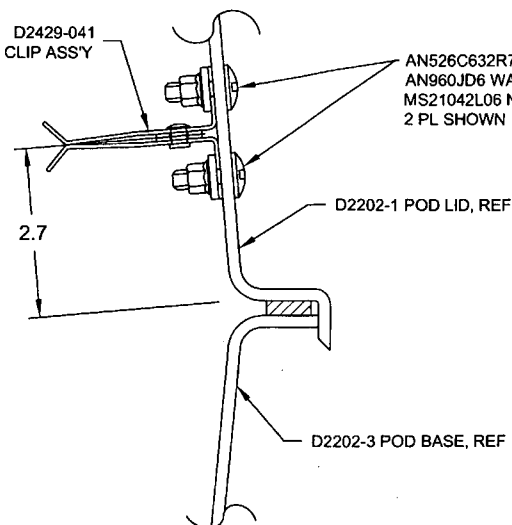
DETAIL A: HINGE  
NOT TO SCALE

10  
C7-2

D2429-041  
SPRING CLIP ASS'Y

AN526C632R7 SCREW  
AN960JD6 WASHER  
MS21042L06 NUT,  
2 PL SHOWN

8



SECTION B-B  
NOT TO SCALE

C5-2

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8 7 6 5 4 3 2 1

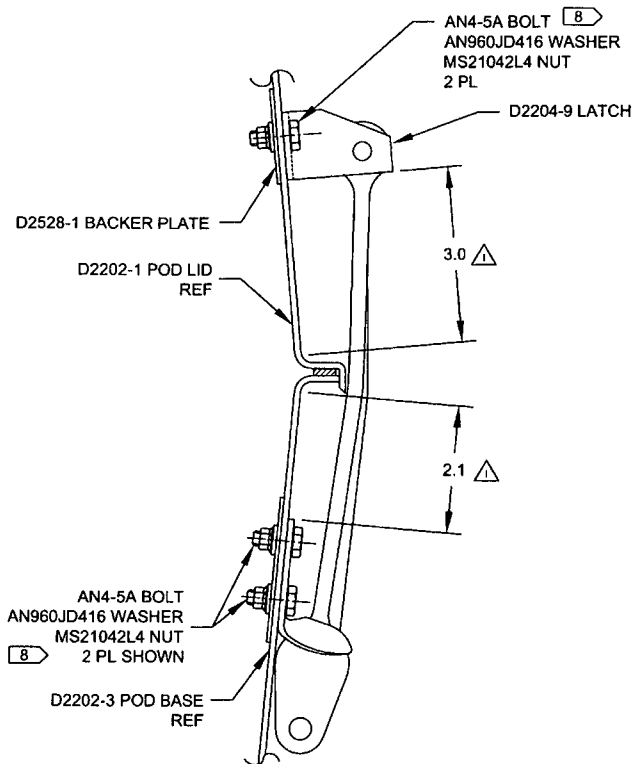
8 7 6 5 4 3 2 1

D

C

B

A



SECTION C-C C3-2, C5-2  
SCALE 10X

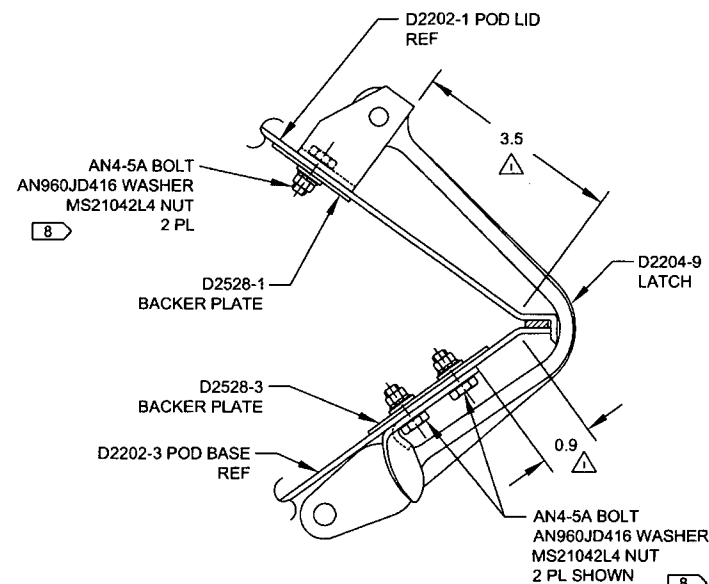
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D

C

B

A

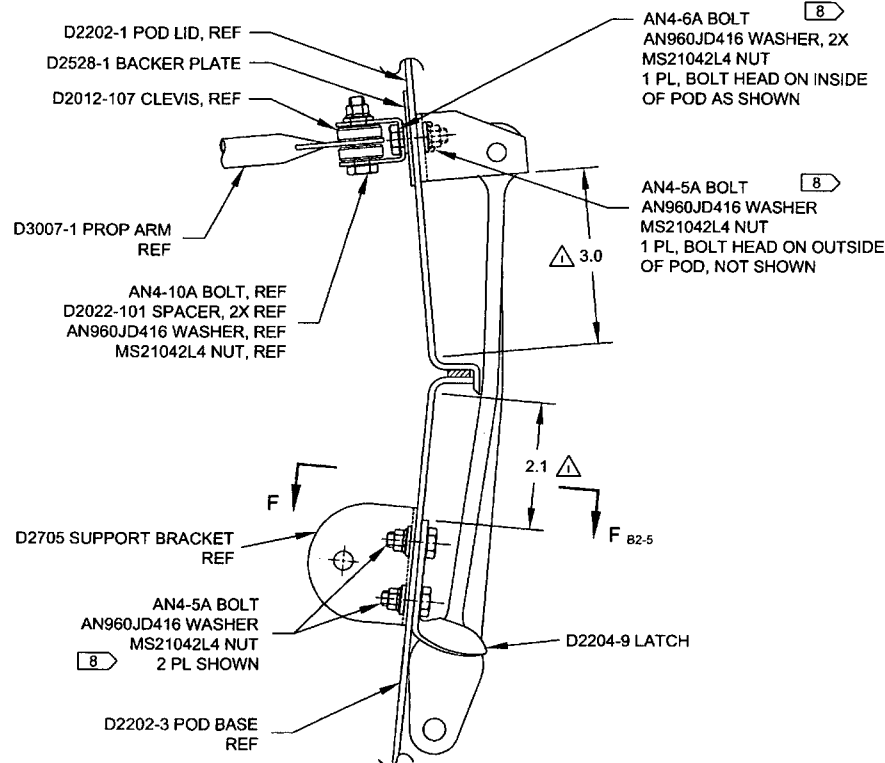


SECTION D-D C6-2  
SCALE 10X

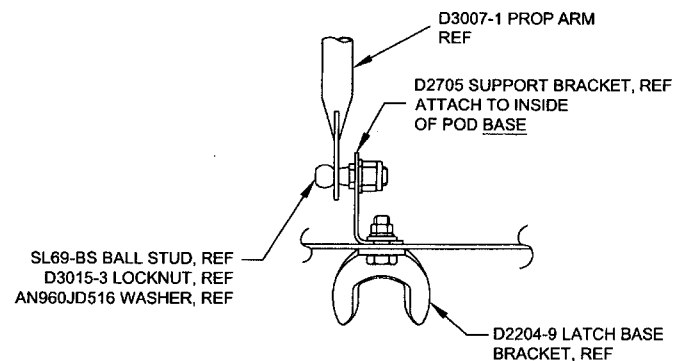
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8 7 6 5 4 3 2 1



SECTION E-E C4-2  
SCALE 10X



SECTION F-F B5-5  
D3007-041 PROP ASSY DETAIL  
SECTION ROTATED 85° CW

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2010-04-29

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8 7 6 5 4 3 2 1